Date: Wednesday, 9/12/2007 12:13:50 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: RING
Job Number	: 34613		
Estimate Number	: 10608		
P.O. Number	: N/A	Part Number	: D2655
This Issue	: 9/12/2007 S.O. No. : N/A	Drawing Number	: D2655 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : PURCHASED PARTS	Drawing Revision	: B
Previous Run	: 33351	Material	: N/A
Written By	:	Due Date	: 9/30/2007 Qty: ~~20~~ 50 Um: Each
Checked & Approved By	: 07.09.12		
Comment	: Est. D 00.06.22 Removed P/O for powder coat EC Est Rev:E Now on Waterjet 06-10-04 JLM		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	M1018B400X250	Inventory

Comment: Qty.: 0.2835 f(s)/Unit Total : 5.6700 f(s)
1018 ASTM A36 .250" thk bar x 4.0"
Batch: M105358 HB 07-09-13

2.0	WATER JET	FLOW WATER JET

(P to) →

Comment: FLOW WATER JET
1-Cut as per Dwg D2655
Dwg Rev: B HB 07-09-13
Prog Rev: B

2-Deburr if necessary /open holes to 0.257" → 07/09/19 50 50

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE

HB 07-09-13

Comment: INSPECT PARTS AS THEY COME OFF MACHINE 50

4.0	QC8	SECOND CHECK

counts

Comment: SECOND CHECK EP 07/09/19 (x50)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1
1-Tumble - .030 Radius
2-Deburr any rough edges after tumbling → 07/09/19 50

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE**		**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes (No) **DQA:** RD **Date:** 07/09/24

QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B **Initial** Chief Eng	**Action Description** Chief Eng	**Sign & Date**	**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
07-09-24	2	PIECE MOVED ON TABLE, 2 PIECES NO good R.C. clamps were not tight enough.	[illegible]	REPLACED SCRAPED DESTROYED	07-09-24	07/09/17	[illegible]	07/09/13

NOTE: Date & initial all entries

Date: Wednesday, 9/12/2007 12:13:50 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** RING

Job Number: 34613 **Part Number:** D2655

Job Number:

Seq. #:	Machine Or Operation:	Description :
6.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP	CS 07/09/24
7.0	POWDER COATING	POWDER COATING
	Comment: POWDER COATING Powder Coat per QSI 005 4.3.5.1	M105068 50X M-h 07/09/20
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
	Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION	CS 07/09/24 (50)
9.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location:_____	CS 07/09/24 (50)
10.0	QC21	FINAL INSPECTION/W/O RELEASE
	Comment: FINAL INSPECTION/W/O RELEASE	(50) DJ 07/09/24

Job Completion

U 07-09-24

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	34613
Description: Ring	Part Number:	D2655
Inspection Dwg: D2655 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø2.00	+0.012/-0.001	2.00	*			
Ø0.257	+0.006/-0.001	.257	*			
Ø3.00	+0.012/-0.001	3.01	*			
0.75	+/-0.030	.75	*			

Measured by:	HB
Date:	07-09-13

Audited by:	CS
Date:	07/08/15

Prototype Approval:	N/A
Date:	N/A

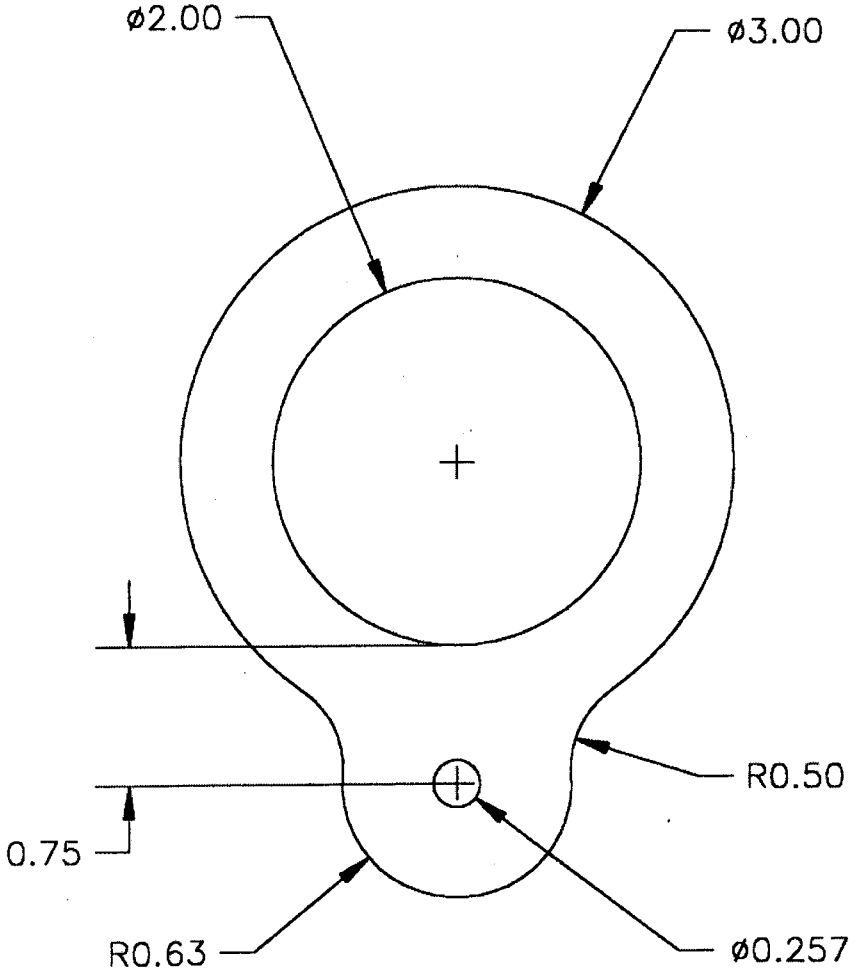
Rev	Date	Change	Revised by	Approved
A	06.10.12	New Issue	KJ/JLM	

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA
CHECKED	APPROVED	DRAWING NO. D2655 REV. B SHEET 1 OF 1
DATE 97:07:07		TITLE RING SCALE 1:1

A	97:03:25	NEW ISSUE
B	97:07:07	ADD ASTM A36 TO MAT. SPEC.

DA COPY ISSUED

RELEASED
97/07/11 DS



NOTE: DEBURR ALL SHARP EDGES
MATERIAL: AISI 1018/1020/1025 OR ASTM A36 0.250 THICK
FINISH: POWDER COAT PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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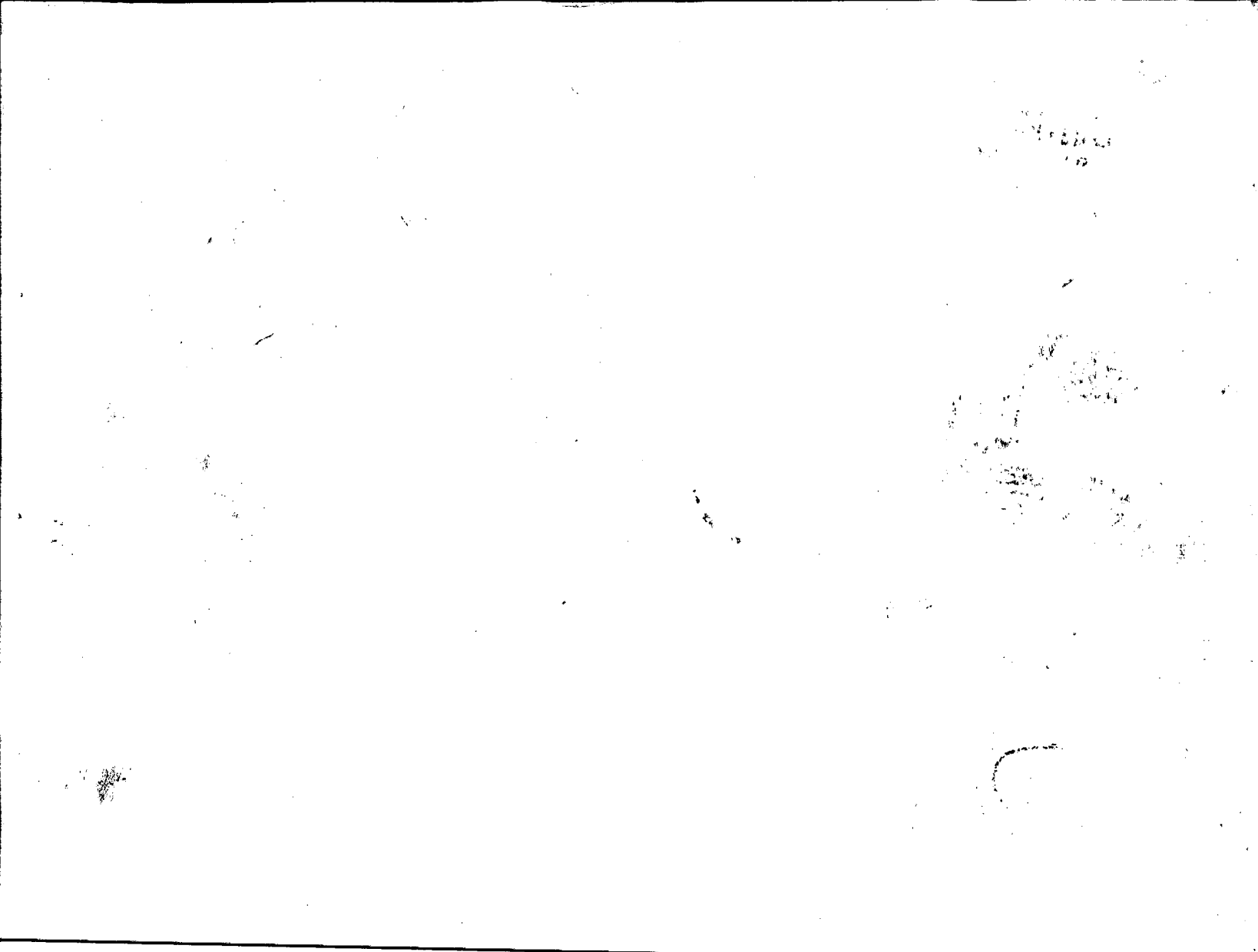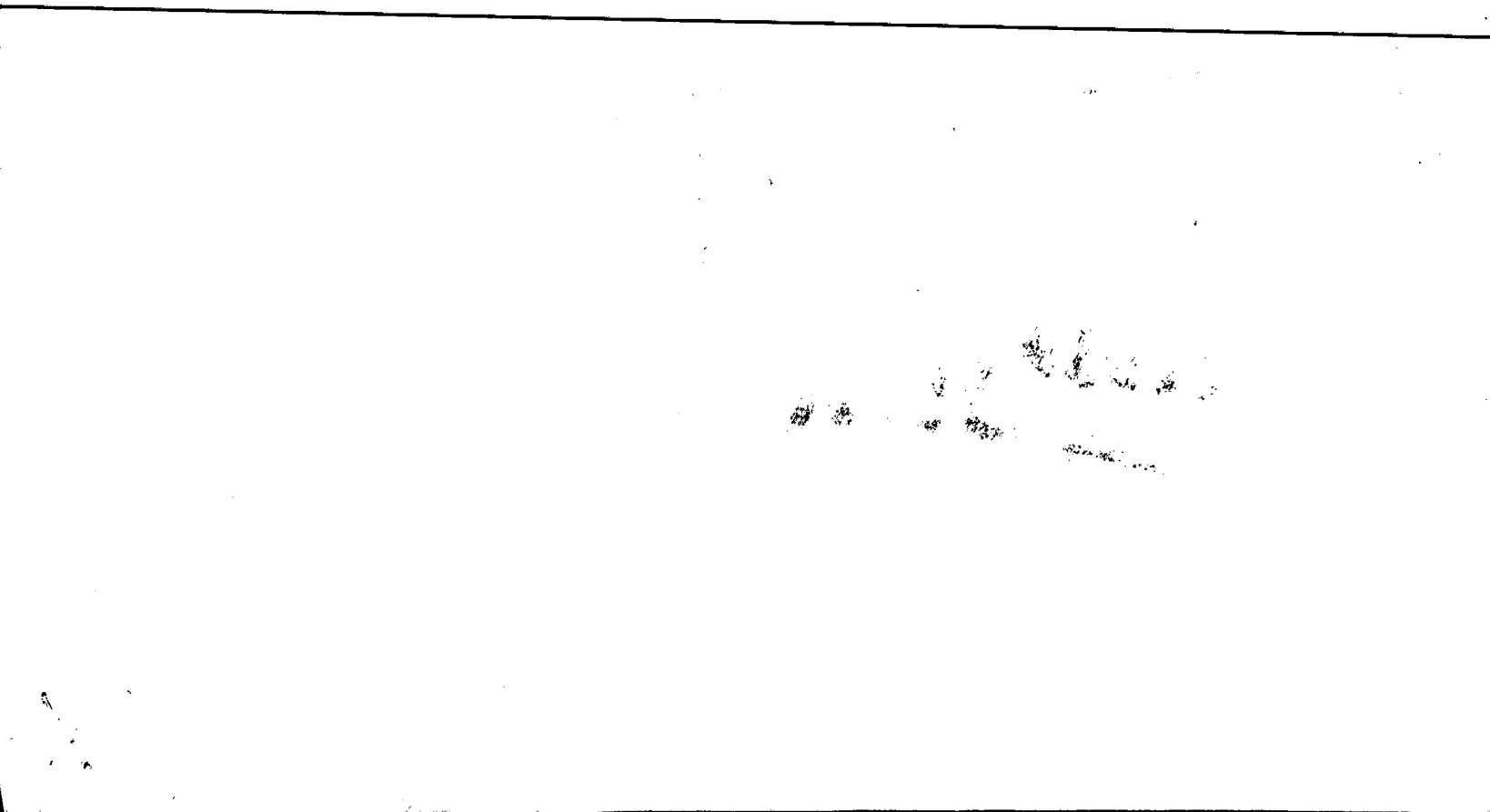
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